

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83903

83903

Page 2

April-27-12 11:15:58 AM

Item ID: D3793-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearshoe
 Start Date: 27/04/2012 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130						13			12/05/16
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary2-Form on Brake as per Dwg D3793 using Jigs 3-Form Joggle on brake using Jig as per Dwg D3793								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:30 OVEN TEMPERATURE: FINISH TIME: 12:00								

M117338

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April-27-12 11:15:58 AM

83903

Page 3

Item ID: D3793-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 27/04/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				13	0		12-5-16
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>FD1</u> Memo	0.00 0.00				13	0		12-5-16
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/5/17 MF 12-05-16

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Picklist Print

April-27-12 11:16:01 AM

Page 1

Work Order ID: 83903

83903

Parent Item: D3793-1

D3793-1

Parent Item Name: Wearshoe

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	296.6329	0.5902	7.455158			

M304S20GA

304/316 .040 Sheet

**

IB12-5-11

Location	Loc Qty	Loc Code
001	52.6444105	
121192	52.6444105	
MAT020	243.9885	
117933	27.3442	
118400	6.3723	
118964	30.2	
119346	29.8	
121380	150.272	

121380

13

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DART AEROSPACE LTD		Work Order:	83903
Description: Wearshoe		Part Number:	D3793-1
Inspection Dwg: D3793	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.191	L		V	
0.300 x 0.300	+/-0.010	301 x 302	L		V	
1.885	+/-0.010	1.895	L		V	
2.000	+/-0.010	2.00	L		V	
5.00	+/-0.030	5.00	Ø		T	
8.00	+/-0.030	8.00	Ø		T	
14.00	+/-0.030	14.00	Ø		T	
20.00	+/-0.030	20.00	L		T	
14.066	+/-0.010	14.066	L		T	
18.983	+/-0.010	18.983	L		T	
23.900	+/-0.010	23.900	L		T	
27.400	+/-0.010	27.400	L		T	
29.400	+/-0.010	29.400	L		T	
32.900	+/-0.010	32.900	Ø		T	
0.040	+/-0.010	.038	2		V	

Measured by: RB	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 12-5-11	Date: 12-05-14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

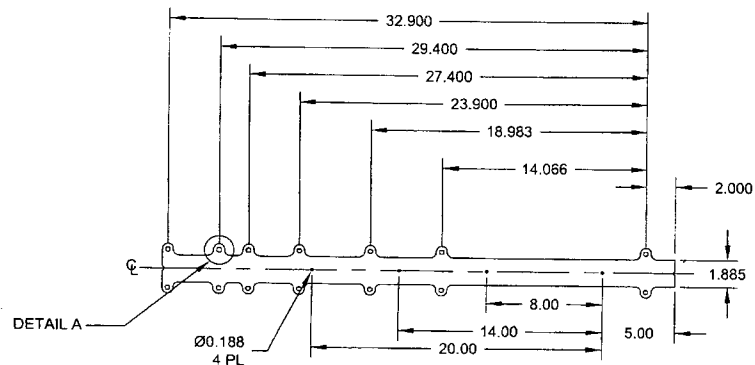
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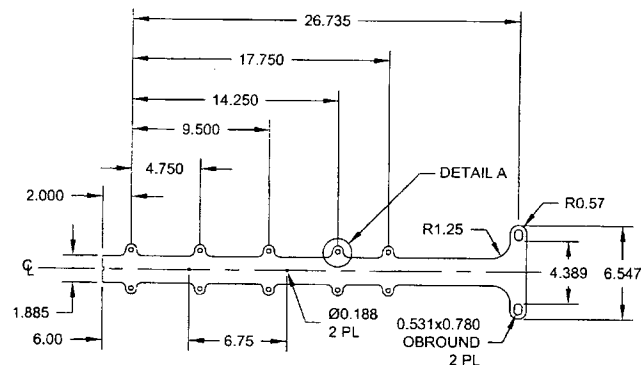
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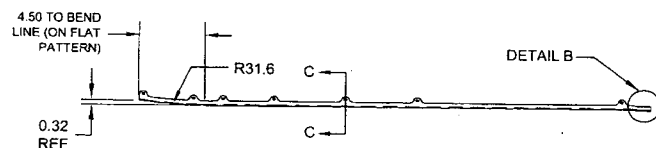
NOTE: Date & initial all entries



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83903 MLJ
12/04/27

RELEASED
08.05.14

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A	NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA		
DRAWN	PH			
CHECKED		DRAWING NO.		REV. A
MFG. APPR.	DA	D3793		SHEET 1 OF 2
APPROVED	PH	TITLE		SCALE
DE APPR.	PH	WEARSHOE		NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC		

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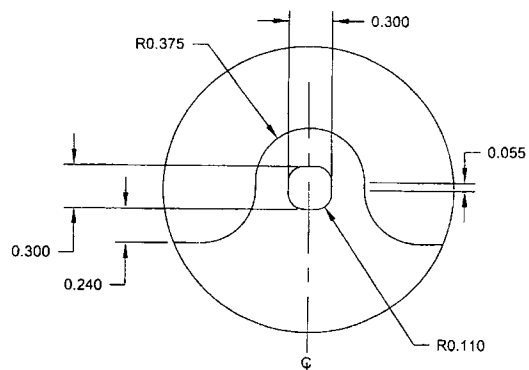
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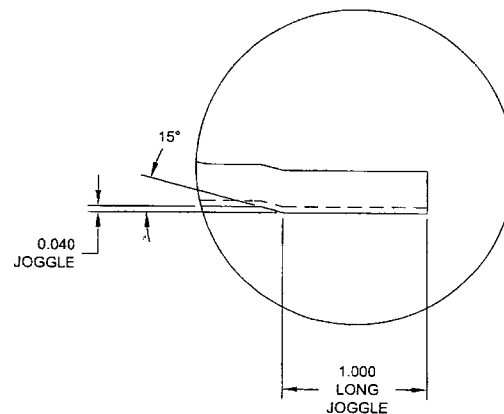
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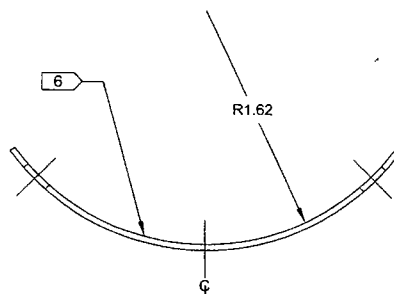
A



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

03903

RELEASED
08-05-14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	DA	D3793	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
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